

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013923**Date Inspected:** 09-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>			

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Welding of tower strut ND1-STSA4-6-123M-1-43. The Welding Procedure was identified as WPS-B-T-2113. The welder was identified as 202338 and was found to be certified in the 3G position with the SMAW process.

Welding of tower strut ND1-STSA4-6-123M -1-44. The Welding Procedure was identified as WPS-B-T-2113. The welders were identified as 054460. Both welders were found to be certified in the 3G position with the SMAW process.

Welding of tower strut ED1-STSA4-6-135M-2-95,96. The Welding Procedure was identified as WPS-B-T-2112. The welder was identified as 251199 and was found to be certified in the 3G position with the SMAW process.

Welding of tower strut ED1-STSA4-6-135M-2-69,70. The Welding Procedure was identified as WPS-B-T-2112. The welder was identified as 206189 and was found to be certified in the 3G position with the SMAW process.

Grinding of weld profiles on tower strut ED1-STSA4-6-127M-1-67 and ND1-STSA4-6-123M-2-79, 64, and 58.

The CWI for the above mentioned operations was identified as An Qin Xiang.

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The ZPMC QC for the above mentioned operations was identified as Mao Bin Bin.

Welding was observed in the heavy dock area on P475W-3, (welder identified as 040724), and P475W-2, (welder identified as 202100). The preheat for the operation was 160C, and the weld procedure was identified as WPS-B-T-4213-Tc-U4c. The QC was identified as Li Jun, and the CWI for the operation was identified as Yun Gi Guo.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Barrentine,Daniel	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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